

GRIBINOX 904L

IDENTIFICATION

GRIBINOX 904L E385-15

CLASSIFICATION

AWS/SFA 5.4: E385-15, DIN 8556-86 E20.25.5L CuB26

DESCRIPTION

A basic type, flux coated electrode designed for welding the fully austenitic stainless steels of the 20% Cr / 25% Ni / 4.5 % Mo / Cu type, used for their very high resistance to corrosion in severe, non-oxidising environments like sulphuric acid. The low carbon, high alloy content of the deposited weld metal gives excellent resistance to intergranular corrosion and stress corrosion cracking combined with superior resistance to crevice and pitting corrosion. The weld metal is of X-ray quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.03 max	1.0 - 2.50	0.75 max	19.5 - 21.5	24.0 - 26.0	4.2 - 5.2	1.2 - 2.0	0.02 max	0.03 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
530 - 630	30 - 42	0°C	60 - 120

TYPICAL APPLICATIONS

- DIN 1.4500, 1.4536, 1.4539, Sandvik, 2RK65, Vddeholm 904L, Avesta 254SLX.
- Tanks, process vessels, piping systems, agitators, rotors, cast pumps and valves for use in the fertiliser, phosphoric, sulphuric acid, acetic acid plants and in salts and sea water environments.

MICROSTRUCTURE

In the welded condition, the weld metal microstructure is fully austenitic (FN-0)

SCALING TEMPERATURE : Approximately 1000°C in air

REDRYING : 250°C / 2 hrs, max 5 cycles, 10 hr. total.

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	50 - 80	2 x 5 = 10	94 x 5 = 470
3.15 / 3.20	350	80 - 120	2 x 5 = 10	60 x 5 = 300

4	350	130 - 180	2 x 5 = 10	38 x 5 = 190
5	350	180 - 220	2 x 5 = 10	24 x 5 = 120